

Work Order ID 129875

February-23-15 10:28:31 AM

129875

Page 1

Item ID: D206-802-030

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Crew Door Opener RH

Stop ***NS2***

Start Date: 2/16/15 Start Qty: 1.00

1

Cust Item ID:

Required Date: 2/23/15 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: MLS Date: 15-02-25 Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN-D407-802-3	A								
100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile and create labels per PPP D206-802-030 CHG002								
105	Pick Kit	0.00							
105									
Packaging	Memo	0.00							
Packaging									
110	QC4- 100% inspect kits for completeness	0.00							
110									
QC	Memo	0.00							
Quality Control									

DAS
27
9-89

DAS
46
9-89

MAY 01 2015

(1x)

DAS
27
9-89
APR 30 2015

DAS
26
9-89

(1x)

DAS
46
9-89

MAY 01 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐															
Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Work Order ID 129875

129875

Page 2

February-23-15 10:28:31 AM

Item ID: D206-802-030

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Crew Door Opener RH

Start Date: 2/16/15

Start Qty: 1.00

1

Cust Item ID:

Required Date: 2/23/15

Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

120

Packaging

Packaging

0.00

0.00

Memo

Identify and pack for shipping as per PPPDD206-802-030

Location: FG-021

PPP rev: _____

(ix)

DAS

46

0.00

MAY 01 2015

130

130

QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

0.00

Memo

MAY 04 2015

MUS

APS-5-1

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

February-23-15 10:28:30 AM

Page 1

Work Order ID: 129875

129875

Parent Item: D206-802-030

D206-802-030

Parent Item Name: Crew Door Opener RH

Start Date: 2/16/15

Required Date: 2/23/15

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 10.12.03 as per dwg rev.A DD verf:EC IPP
REV:B 11-06-06 AS PER DSI9560 JLM VERIFIED BY:EC IPP Rev:C
12.07.30 AS PER ECN12-624 DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3552-15 *D3552-15* Door Prop	DAS 46 9-89	Manufactured	No			105	Each	6.0000	1	1			69-6 92 5-10
				<u>Location</u>				<u>Loc Qty</u>					
				ST363				6					
				121617				4					
				88T00				2					
D3622-5 *D3622-5* Ball Stud	DAS 46 9-89	Manufactured	No			105	Each	24.0000	2	2			DAS 26 19-89
				<u>Location</u>				<u>Loc Qty</u>					
				ST052				24				DAS 27 8-89	
				104978				24					
D4110-3 *D4110-3* Doubler, Sill	DAS 46 9-89	Manufactured	No			105	Each	2.0000	1	1			DAS 26 9-89
				<u>Location</u>				<u>Loc Qty</u>					
				ST091				2					
				121635				2					
D4114-2 *D4114-2* Door Doubler, RH	DAS 46 9-89	Manufactured	No			105	Each	1.0000	1	1			DAS 26 9-89
				<u>Location</u>				<u>Loc Qty</u>					
				ST092				1					
				97620				1					

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Crosstube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

February-23-15 10:28:30 AM

Page 2

Work Order ID: 129875

129875

Parent Item: D206-802-030

D206-802-030

Parent Item Name: Crew Door Opener RH

Start Date: 2/16/15

Required Date: 2/23/15

Start Qty: 1.00

Required Qty: 1.00

MS20426AD4-5

Purchased

No

105

Each

2,515.000

4 4

MS20426AD4-5

RIVET

DAS
46
9-89

Location

Loc Qty

Loc Code

GA

2441

m125807

60

m130922

2381

ST312

74

m125807

74

MS20600-AD4W2

Purchased

No

105

Each

1,001.000

32 32

MS20600-AD4W2

Rivet

DAS
46
9-89

Location

Loc Qty

Loc Code

CCK004

800

m126475

800

GA

154

m125708

154

ST309

47

m126475

47

MS21073LS

Purchased

No

105

Each

52.0000

2 2

MS21073LS

Anchor Nut

DAS
46
9-89

Location

Loc Qty

Loc Code

ST300

52

m130799

6

m131087

46

DAS
27
9-89

APR 30 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

February-23-15 10:28:30 AM

Page 3

Work Order ID: 129875

Parent Item: D206-802-030

Parent Item Name: Crew Door Opener RH

129875

D206-802-030

Start Date: 2/16/15

Required Date: 2/23/15

Start Qty: 1.00

Required Qty: 1.00

NAS1149C0532R

Purchased

No

105

Each

477.0000

6

6

~~NAS1149C0532R~~

DAS

46

WASHER

9-89

**

DAS

27

9-89

DAS

26

9-89

Location

Loc Qty

Loc Code

GA

62

116513

62

ST271

415

m128537

215

m131624

200

NAS1149C0563R

Purchased

No

105

Each

346.0000

6

6

~~NAS1149C0563R~~

DAS

46

Washer

9-89

**

DAS

27

9-89

DAS

26

9-89

Location

Loc Qty

Loc Code

ST271

346

m125928

5

m131026

341

MS27130-A26

Purchased

No

105

Each

55.0000

1

1

~~MS27130-A26~~

DAS

46

Rivnut

9-89

**

DAS

27

9-89

DAS

26

9-89

Location

Loc Qty

Loc Code

ST279

55

116521

55

APR 30 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
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Offset/Setup									
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Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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REFERENCE ONLY

DART AEROSPACE LTD.

MAY 01 2015

DAS
46
9-89

IIN-D206-802-3
Page 22 of 24

5.0 PARTS LIST

5.1 D206-802-029/-030 Crew Door Opener Kits

Qty -029	Qty -030	Part Number	Description
		D206-802-029	CREW DOOR OPENER KIT, LH
		D206-802-030	CREW DOOR OPENER KIT, RH
1	1	D3552-15	DOOR PROP
1	1	D3622-5	BALL STUD
1	1	D4110-3	DOUBLER, SILL
1		D4114-1	DOOR DOUBLER, LH
	1	D4114-2	DOOR DOUBLER, RH
4	4	MS20426AD4-5	RIVET
32	32	MS20600AD4W2	RIVET
2	2	MS21073L5	ANCHOR NUT
1	1	MS27130-A26	RIVNUT
6	6	NAS1149C0532R	WASHER
6	6	NAS1149C0563R	WASHER

5.2 D206-802-031/-032 Passenger Door Opener Kits

Qty -031	Qty -032	Part Number	Description
		D206-802-031	PASSENGER DOOR OPENER KIT, LH
		D206-802-032	PASSENGER DOOR OPENER KIT, RH
1	1	D3552-17	DOOR PROP
1	2	D3622-5	BALL STUD
	1	D4112-1	AFT SILL DOUBLER
1	1	D4115-5	DOUBLER
1		D4115-041	LITTER DOOR BRACKET ASSY
3		CR3242-5-4	RIVET
2		CR3243-5-4	RIVET
2	4	MS20426AD4-5	RIVET
9	14	MS20600AD4W2	RIVET
1	2	MS21073L5	ANCHOR NUT
3	6	NAS1149C0532R	WASHER
3	6	NAS1149C0563R	WASHER

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Revision: A
Date: 10.10.13

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D206-802-3 Rev. A AND ICA-D407-802 REV. 0

REF CANADIAN STC: SH10-44

REF FAA STC: SR02933NY

REF EASA STC: 10033253

PURPOSE:

THE PURPOSE OF THIS DART SERVICE INSTRUCTION (DSI) IS TO CORRECT ERRORS IN THE PARTS LISTS OF THE INSTALLATION INSTRUCTIONS IIN-D206-802-3 REV. A AND ICA-D407-802 REV. 0 (-029 AND -030).

PARTS LIST CHANGE:

- 5.1 D206-802-029/-030 Crew Door Opener Kits (IIN-D206-802-3 Rev. A)
52.4.8 D206-802-029/-030 Crew Door Opener Kits (ICA-D407-802 Rev. 0)

QTY. -029	QTY. -030	PART NUMBER	DESCRIPTION
2		D206-802-029	CREW DOOR OPENER KIT, LH
	2	D206-802-030	CREW DOOR OPENER KIT, RH

IS:

2	2	D3622-5	BALL STUD
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WAS:

1	1	D3622-5	BALL STUD
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CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED
BY: 
D. SHEPHERD (DE # 02)

DATE: 11.05.20
CERT. NO.: SH10-44
ISSUE NO.: 1

A	NEW ISSUE	AJS	11.05.20
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD	
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